

Work Order ID 82110

82110

Page 1

March-22-12 4:32:20 PM

Item ID: D2892-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support

Start Date: 22/03/2012 Start Qty: 14.00

14

Cust Item ID:

Required Date: 30/04/2012 Req'd Qty: 14.00

14

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/22 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2892

B

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

FK 12/04/05

10

φ

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA082
2-Deburr

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

FK 12/04/05

10

φ

QC

Memo

0.00

Quality Control

120

0.00

120

QC8- Inspect parts - second check

B.A 12/04/08

10

φ

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
HandFXtube	Memo	0.00							
Hand Finishing Crosstubes	Per note 8 on page 1 of dwg D2892, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>L652</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									

AP 12 - 4 - 9 (10)

(10) 12-04-10

AP 12 - 4 - 10 (10)

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Work Order ID 82110***82110***

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/4/12

12-04-12

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Picklist Print

March-22-12 4:32:24 PM

Page 1

Work Order ID: 82110

82110

Parent Item: D2892-1

D2892-1

Parent Item Name: Support

Start Date: 22/03/2012

Required Date: 30/04/2012

Start Qty: 14.00

Required Qty: 14.00

Comments:

IPP C02.11.26Added P/O KJ

IPP D 08.03.19 Re-format EC verified by: DD

IPP Rev:E

11.08.04 as per dwg rev.B DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK077		Manufactured	No			110	Each	0.0000	0.5	7			

DSK077

D2892-1 TURNING DETAIL

**

FK

12/04/05

80215 x 5

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	82110
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.115	0.135 - .150		.136	.136	.136	.136	.136
AB	0.290	0.310		.300	.300	.300	.300	.300
AC	0.040	0.060		.050	.050	.050	.050	.050
AD	0.115	0.135		.127	.127	.127	.127	.127
AE	0.240	0.260		.250	.250	.250	.250	.250
AF	0.188	0.193		.188	.188	.188	.188	.188
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.143	1.142	1.140	1.139	1.140
AI	0.454	0.474		.462	.464	.462	.462	.461
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.259	.259	.259	.259	.259
AM	1.663	1.683		1.672	1.672	1.673	1.673	1.673
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: F.K. Date: 12/04/05

Audited by: J.A. Date: 12/04/08

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.01.31	Dwg Rev updated	KJ	

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DART AEROSPACE LTD		Work Order:	82110
Description: Ø2.500 Support		Part Number:	D2892-1
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AF	0.188	0.193		.188	.188	.188	.188	.188
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.140	1.138	1.142	1.142	1.140
AI	0.454	0.474		.462	.460	.460	.461	.461
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.259	.259	.259	.260	.260
AM	1.663	1.683		1.673	1.673	1.673	1.673	1.673
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Measured by: F.K. Date: 12/04/05

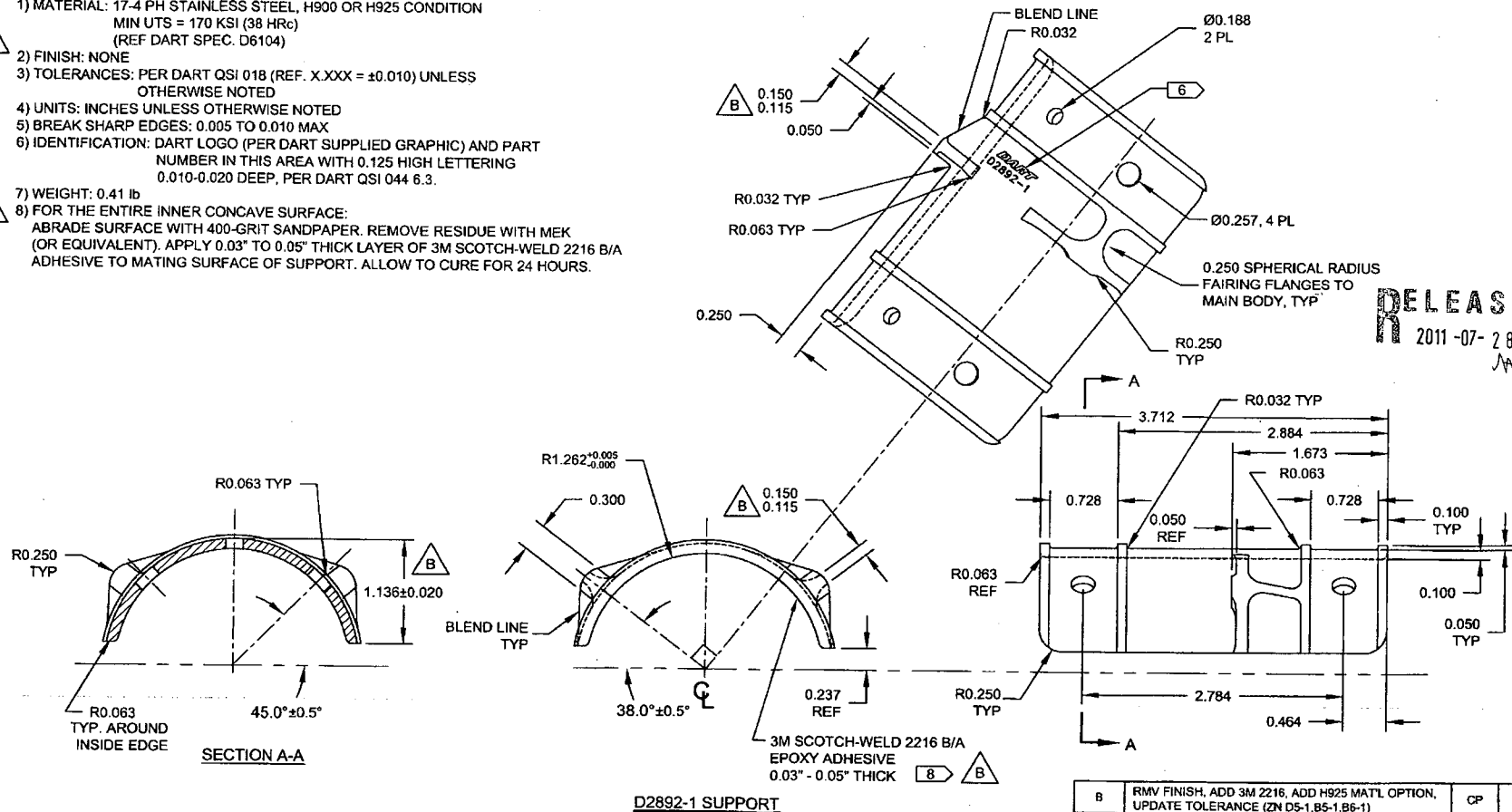
Audited by: B.A. Date: 12/04/08

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NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRc)
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF. X.XXX = ± 0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.
- 7) WEIGHT: 0.41 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.



RELEASED
2011-07-28

B	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION, UPDATE TOLERANCE (ZN DS-1.B5-1.B6-1)	CP	11.07.15
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	q		
DRAWN	q		
CHECKED	ASS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2892
REV. B
SHEET 1 OF 1
TITLE Ø2.500 SUPPORT
SCALE NTS

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WITHOUT NOTICE
WORK ORDER

NO. 02110 M/LJ
12/03/22

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